

Work Order ID 57253

March 31, 2010 10:04:08 AM



Page 1

Item ID: D3072-2

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 31/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-3-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3072

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

10-3-31

FLOW CNC Waterjet

1-Cut as per Dwg D3072 (D3072-101 flat pattern) ☐ Dwg

Rev: A1 ☐ Prog Rev: A1 ☐ 2-Deburr if necessary

5052 - 090

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

10-3-31

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Scalory 01

45

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- deburr if necessary □ 2- Bend as per dwg D3072

88 10/04/05

14

1

PTO

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 10/04/05

X14

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

ed 10/04/06

X14

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3072-2 PAR #: N/A Fault Category: Sm fab NCR: (Yes) No DQA: 10 Date: 10-04-27
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: _____ Date: _____

NCR: <u>57253</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/05</u>	<u>130</u>	<u>part at the set-up was out of toleran</u> <u>R.C Process</u>	<u>[Signature]</u> <u>09/04/05</u>	<u>Scrap & destroy</u>	<u>SD</u> <u>10/04/05</u>	<u>6</u> <u>10/04/05</u>	<u>[Signature]</u> <u>05/04/05</u>	<u>[Signature]</u> <u>10-04-05</u>

NOTE: Date & initial all entries

Work Order ID 57253

March 31, 2010 10:04:08 AM



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Item ID: D3072-2

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Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 31/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



M105642

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:45am OVEN TEMPERATURE: 320°F
FINISH TIME: 12:15pm

=) 10/04/07

X 10

Ø

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-4-7

(14)

Ø

180

Identify as per dwg & Stock Location: 035

0.00



Packaging

Memo

0.00

Packaging

10/4/9 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Start Date: 31/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12

mmf

10-4-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 31, 2010 10:04:12 AM

Page 1

Work Order ID: 57253



Parent Item: D3072-2



Parent Item Name: Bracket

Start Date: 31/03/2010

Required Date: 09/04/2010

Comments: IPP B02.01.18 Flat pattern created on dash 101. NG
IPP Rev:C 08-02-26 now water jet DD verified by:LL

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.090		Purchased	No			100	sf	49.3000	1.2284			



5052-H32 .090 Sheet



10-3-31

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT22

49.3

100782

17.3

3019

32

100782

W/O:		WORK ORDER CHANGES					
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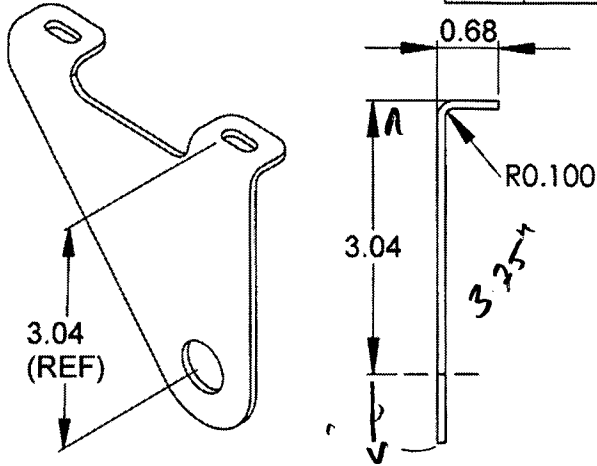
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3072	REV. A SHEET 1 OF 1
DATE 01.12.16	TITLE BRACKET		SCALE 1:1
A	01.12.16	NEW ISSUE	
A1 02.01.18		ADD FLAT PATTERN PART NUMBER # CP	



D3072-1/-2 BRACKET

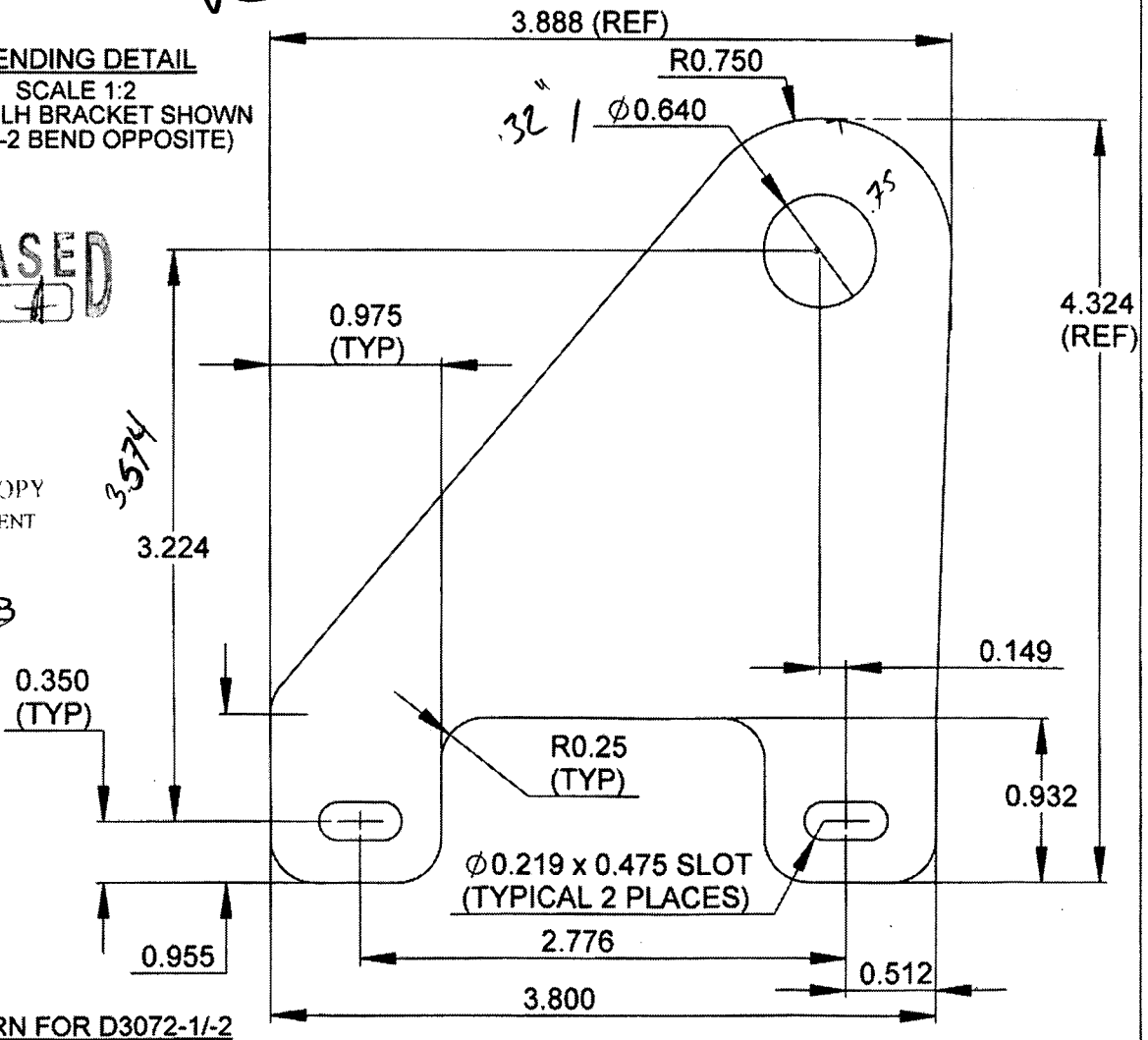
- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/ QQ-A-250/8) 0.090 THICK
- 2) FINISH: POWDER COATBLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

BENDING DETAIL

SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

RELEASED
02.01.15

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57253



D3072-101

FLAT PATTERN FOR D3072-1/-2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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